

Date: Thursday, 22/05/2008 1:31:51 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 SKIDTUBE "I" BEAM
Job Number : 39426	
Estimate Number : 10346	
P.O. Number :	Part Number : D2596
This Issue : 22/05/2008 S.O. No. :	Drawing Number : D2596 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : D
Previous Run : 39177	Material :
Written By :	Due Date : 10/06/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JMO 08.5.22</u>	
Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -I" Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	B-33940

AWM
8-5-22

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

AWM
8-5-22

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid Etch and Alodine per QSI 005 4.1

AWM
8-5-22

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2E 08/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/05/2008 1:31:52 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 39426

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SKID TUBE CELL

AWM

8-5-23

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DART AEROSPACE LTD
HAWESBURY, ONTARIO, CANADA

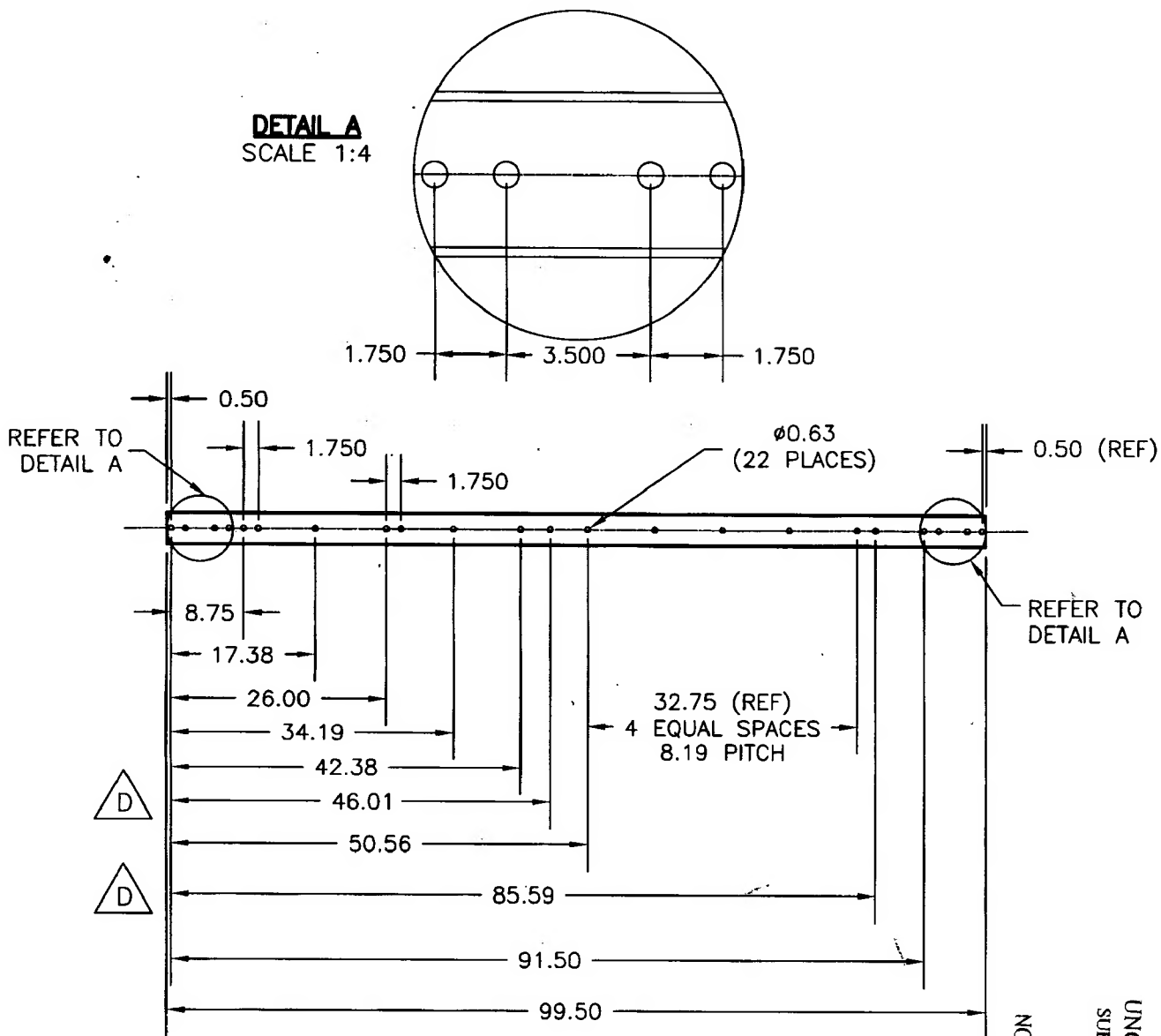
DESIGN	DRAWN BY	DRAWING NO.	REV. D
84	84	D2596	SHEET 1 OF 1
CHECKED	APPROVED	TITLE	SCALE
84	84	205 WEB	1:20
DATE			
07.04.17			

RELEASED
07.06.18

A	96.09.16	NEW ISSUE
B	97.07.23	Ø0.63 HOLE WAS Ø0.56
C	98.09.14	INCORPORATED DEO 9097
D	07.04.17	INCORPORATED DEO 9183SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39426

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries